

Work Order ID 153450***153450***

Page 1

Monday, November 21, 2016 9:27:46 AM

Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

DAS
21
9-89Approvals: Process Plan: Date: NOV 21 2016

Tooling:

Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750-042

G

D3492

E

DEC 07 2016

0.00

DAS
6
9-89DAS
27
9-89DAS
21
9-89

DEC 08 2016

100

Document Control

DOCUMENT CONTROL

100

DC

Doc.Control -USB or Paperwork

Memo

record fwd angle: 89.9°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DEC 08 2016

1 Ø 16-11-23DAS
19
9-89

B153450 R+1

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 2

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N900040100

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

0.17

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16",
then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN
first side. Repeat process on second side.*****ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP
WHEN DRILLING FIRST SIDE*****Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig
DT8150 & DT8863A for second side only DT8863B for first side (detail K)4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND
ANGLE.6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

16-11-22 DTc BH

16-11-23 JH

BE 16-11-23

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 3

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Process Plan: _____

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Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampA/R Aluminum Rod batch: M133750

9- Grind welds flush as per Dwg D2750

78E16-1123

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

OAS
38
9-89

NOV 24 2016

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

OAS
38
9-89

NOV 24 2016

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 4

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140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.06

Hand Finishing

1 ϕ 16-11-24

DAS
79
250

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

tw 16-11-25

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 5

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.17

1- Open up holes of Detail L using hole saw and ground handling to 0.625"
(total of 8 holes per side) as per dwg D2750.2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750
(welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 3136093exp. date: 17-02-16****ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)****8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 9)

A/R Aluminum Rod

batch: M133750

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

16-11-25 D7

78616-11-28
16-11-29

Work Order ID 153450***153450***

Page 6

Monday, November 21, 2016 9:27:46 AM

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11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

VERIFY C'BOARD IS GOOD

DAS
38

NOV 30 2016

DAS
38

NOV 30 2016

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 7

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.07

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1DAS
41
9-89
16-12-3

200

0.00

200

SprayPaint

Memo

0.07

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 135729

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 1360401DAS
41
9-89
16-12-3

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

11211 c/ JEB 16/12/15
DAS
15
9-89

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 8

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish								
Hand Finishing	Memo	0.19							
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M1136093</u>								
	EXP DATE: <u>12109</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M135473</u>								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M133640</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC								
Quality Control	Memo	0.00							

DAS
38
9-89

DEC 07 2016

Work Order ID 153450***153450***

Page 9

Monday, November 21, 2016 9:27:46 AM

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

DAS
6
9-89DAS
28
9-89

DEC 08 2016

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.01

Quality Control

DAS
27
9-89

DEC 08 2016

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012
Location : FG072DAS
21
9-89
DAS
21
9-89

DEC 08 2016

DEC 08 2016

Work Order ID 153450

Monday, November 21, 2016 9:27:46 AM

153450

Page 10

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280							DAS		
QC	Memo	0.02					21		
Quality Control							9-89		

DEC 08 2016

DEC 08 2016

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Page 1

13

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-29 As per Rev D EC IPP REV: K
AS PER REV F JLM 13-08-22 VERIFIED BY: DD
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
IPP Rev: N 08-09-23 rev F as per dwg DD verified by: ec IPP Rev: O
10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as
per IIN rev H DD verf: EC IPP REV: Q 13.08.27 PER ECN 13-
594 DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT-RH

Manufactured

No

110

Each

7.0000

1

1

D2600-3-BENT-RH

Extrusion Bent RH

**

16-11-22 DT

Location

Loc Qty

Loc Code

LG002

7

150499

7

D2744

Manufactured

No

110

Each

22.0000

1

1

D2744

Cap

**

8616-11-23

Location

Loc Qty

Loc Code

LG001

22

145790

12

150653

10

D2739

Manufactured

No

160

Each

9.0000

1

1

D2739

350 I Beam

**

16-11-25 DT

Location

Loc Qty

Loc Code

LG002

9

150718

9

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Page 2

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Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

134.0000

8

8

D2743

Crossbolt Spacer

**

BE16-11-28

Location

Loc Qty

Loc Code

LG001

134

147561

8

150407

126

8

D3490-3

Manufactured No

160

Each

31.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE16-11-28

Location

Loc Qty

Loc Code

LG001

31

137807

2

140801

1

150497

28

4

D3490-1

Manufactured No

160

Each

45.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE16-11-28

Location

Loc Qty

Loc Code

LG001

45

134019

4

150496

41

4

D3631-1

Manufactured No

230

Each

159.0000

8

8

D3631-1

Washer

**

BE16-11-28

Location

Loc Qty

Loc Code

FP001

159

147068

7

148837

52

150675

100

VB

Monday, November 21, 2016 9:27:49 AM

Shop Packet Print

Page 2

Picklist Print

Monday, November 21, 2016 9:27:49 AM

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Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3791-1	Manufactured	No	230	Each	8.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D3791-1

Wearpad

**

ll 16/11/07

LocationLoc QtyLoc Code

FP002

8

B155660

x1

148677

8

D3793-3	Manufactured	No	230	Each	17.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3793-3

Wearplate Aft

**

ll 16/12/07

LocationLoc QtyLoc Code

FP002

17

B153466

x1

148620

5

150138

12

MS21043-6	Purchased	No	230	Each	87.0000	4	4
-----------	-----------	----	-----	------	---------	---	---

MS21043-6

NUT

**

ll 16/12/07

LocationLoc QtyLoc Code

FG

20

103693

20

FP001

57

m135470

30

m135603

2

m136047

25

ST302

10

m134817

10

x1

x3

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Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

20.0000 1 1

D3794-1

Gasket Fwd

**

lll 11/21/16

Location

Loc Qty

Loc Code

FP001

20

142770

1

147682

1

150417

6

150695

12

xc

NAS1611-010

Purchased No

230 Each

161.0000 8 8

NAS1611-010

O-RING

**

lll 11/21/16

Location

Loc Qty

Loc Code

FP001

161

m134955

7

m135603

154

ve

D2741

Manufactured No

250 Each

60.0000 1 1

D2741

Replacement Blade

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

50

132981

15

148028

35

DAS
27
9-89

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Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

175.0000

4

4

***NAS1515H3I ***

Washer

ll 16/12/07

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

31

m127831

20

m134508

11

ST260a

100

m135600

100

ST266

4

m130726

4

x 4

NAS1611-013

Purchased

No

230

Each

227.0000

8

8

NAS1611-013

O-Ring

ll 16/12/07

Location

Loc Qty

Loc Code

FP001

227

m134676

30

m135544

93

m135603

104

x 2

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Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

177.0000

4

4

AN3C6A

Bolt

**

JL 12/1/07

LocationLoc QtyLoc Code

FG

10

122416

10

FP001

72

m135704

72

OVER002

60

m135442

60

ST349

35

m128704

27

m132767

2

m133077

6

x4

NAS1149C0832R

Purchased

No

230

Each

125.0000

1

1

NAS1149C0832R

Washer

**

JL 12/1/07

LocationLoc QtyLoc Code

FP001

23

m125807

23

ST265

102

m135536

102

x1

D3536-25

Manufactured

No

230

Each

19.0000

1

1

D3536-25

Gasket Center

**

JL 12/1/07

LocationLoc QtyLoc Code

FG

6

87053

2

95328

4

FP001

13

146747

2

150578

11

B153641

x1

Monday, November 21, 2016 9:27:49 AM

Shop Packet Print

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Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

25.0000

1

1

D3794-3

Gasket Aft

xl 11/21/16

Location

Loc Qty

Loc Code

FP001

25

147325

1

150181

13

150612

11

xl

AN3C5A

Purchased

No

230

Each

1,248.000

34

34

AN3C5A

Bolt

xl 11/21/16

Location

Loc Qty

Loc Code

FG

5

122800

5

M136295

x34

FP001

130

M135603

130

OVER002

900

M135948

400

M136047

500

ST350

213

M134676

13

M135442

200

Picklist Print

Page 8

Monday, November 21, 2016 9:27:49 AM

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

145.0000

3

3

D3537-1

Wearpad

all 12/12/07

Location

Loc Qty

Loc Code

FG

14

79833

4

88562

10

FP001

130

141922

7

147593

36

150462

34

150709

1

151518

52

ST184

1

125911

1

D3535-25

Manufactured No

230

Each

15.0000

1

1

D3535-25

Wearplate Center

all 12/12/07

Location

Loc Qty

Loc Code

FG

4

139987

1

148669

1

95077

2

FP002

11

148669

3

150650

8

xl

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

154.0000

8

8

D3492-3

Plug

all 16/12/07

Location

Loc Qty

Loc Code

FP001

154

142869

3

147535

26

150361

125

x8

NAS1149C0332R

Purchased

No

230

Each

3,522.000

38

38

NAS1149C0332R

WASHER

all 16/12/07

Location

Loc Qty

Loc Code

FP001

880

m135672

568

m135948

312

11136199

L30

GA

86

m133284

86

ST260a

1500

m135466

1000

m136042

500

ST266

1056

m135408

356

m135766

500

m135908

200

D3488-042

Manufactured

No

230

Each

12.0000

1

1

D3488-042

Blade Fitting RH

all 16/12/07

Location

Loc Qty

Loc Code

FP001

12

144738

2

148618

4

150126

6

x1

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

5,207.000

38

38

AI S4-1032-225

Rivnut

**

16/12/07

Location

Loc Qty

Loc Code

CCK007

5000

M135998

5000

x38

FG

20

M134975

20

FP001

187

M135603

40

M135920

147

D3492-1

Manufactured

No

230

Each

135.0000

8

8

D3492-1

Plug

**

14/12/07

Location

Loc Qty

Loc Code

FP001

135

148723

4

150701

131

x8

D3793-1

Manufactured

No

230

Each

17.0000

1

1

D3793-1

Wearplate Fwd

**

16/12/07

Location

Loc Qty

Loc Code

FP002

17

148647

5

150194

12

x1

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

AN8C35A	Purchased	No	230	Each	64.0000	1	1	
AN8C35A						**		<u>ll 16/12/07</u>
Bolt								

Location	Loc Qty	Loc Code
FG	5	
121275	5	
FP001	29	
m133336	15	
m134130	14	
over005	30	
m134131	15	
m134133	15	

MS21083C8	Purchased	No	230	Each	81.0000	1	1	
MS21083C8						**		<u>ll 16/12/07</u>
Nut								

Location	Loc Qty	Loc Code
FP001	14	
m135603	14	
ST297	67	
m135297	25	
m135470	2	
m136047	40	

D2745	Manufactured	No	230	Each	38.0000	8	8	
D2745						**		<u>ll 16/12/07</u>
Bushing								

Location	Loc Qty	Loc Code
FP001	38	
129584	7	
136214	2	
145904	29	

B150681

x8

Picklist Print

Monday, November 21, 2016 9:27:49 AM

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

all 16/12/07

Location

Loc Qty

Loc Code

FP001

62

131649

50

m132556

12

over009

314

m132556

210

m135718

52

m135719

52

x4

D3532-1

Manufactured

No

250

Each

35.0000

2

2

D3532-1

Spacer

**

DAS
6
9-89

DEC 08 2016

Location

Loc Qty

Loc Code

ST041

35

144630

5

150708

30

2

MS21083C8

Purchased

No

250

Each

81.0000

2

2

MS21083C8

Nut

**

DAS
6
9-89

DEC 08 2016

Location

Loc Qty

Loc Code

FP001

14

m135603

14

ST297

67

m135297

25

m135470

2

m136047

40

2

Picklist Print

Monday, November 21, 2016 9:27:50 AM

Page 13

Work Order ID: 153450

153450

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

426.0000

2

2

NAS1149D0863J

Washer

DEC 08 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

280

125268

280

D3493-1

Manufactured

No

250

Each

46.0000

2

2

D3493-1

Washer

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST039

36

140678

16

150677

20

DEC 08 2016

DAS 6 9-89

DAS 28 9-89

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

AN8C21A

Purchased

No

250

Each

28.0000

2

2

AN8C21A

Bolt

136262

DEC 08 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

ST332

24

m132169

2

m132522

1

m134590

21

Monday, November 21, 2016 9:27:50 AM

Shop Packet Print

Page 13

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153450 MJS
16-11-21

RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	06.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	06.09.01
A	NEW ISSUE	DS	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

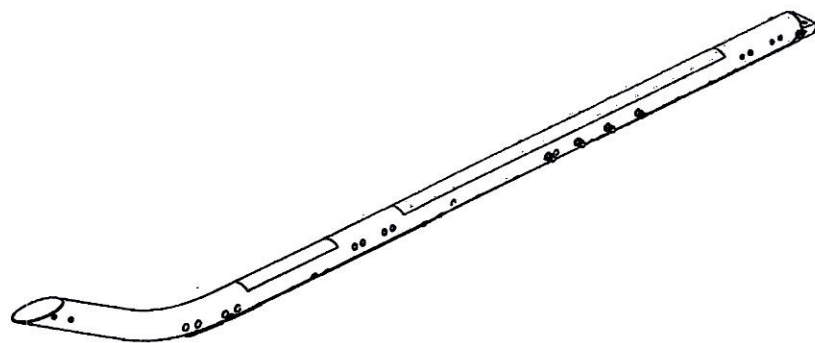
KENT, WA

DRAWING NO. D2750

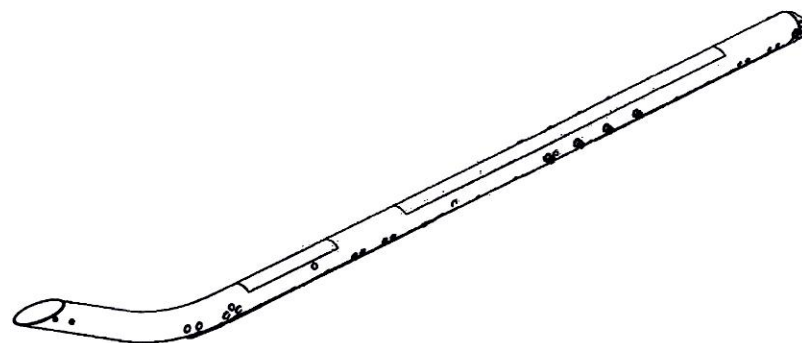
TITLE 350 SKIDTUBE ASSEMBLY

REV. G SHEET 1 OF 11 SCALE NTS

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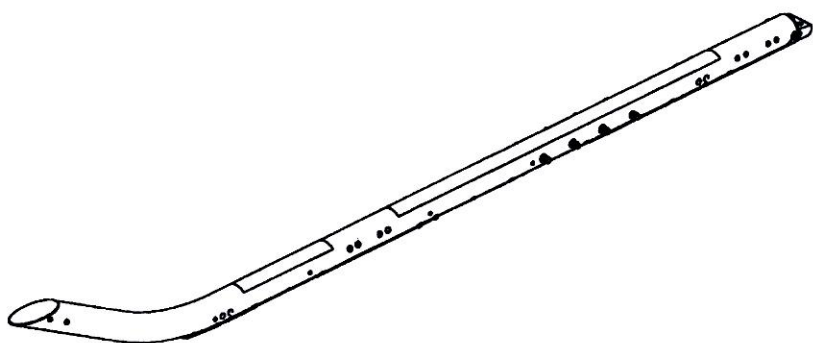
D2750-041 350 SKIDTUBE ASSEMBLY, LH



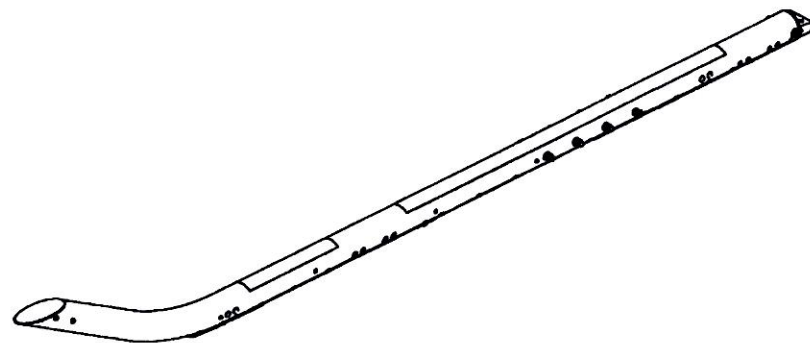
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
MD

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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

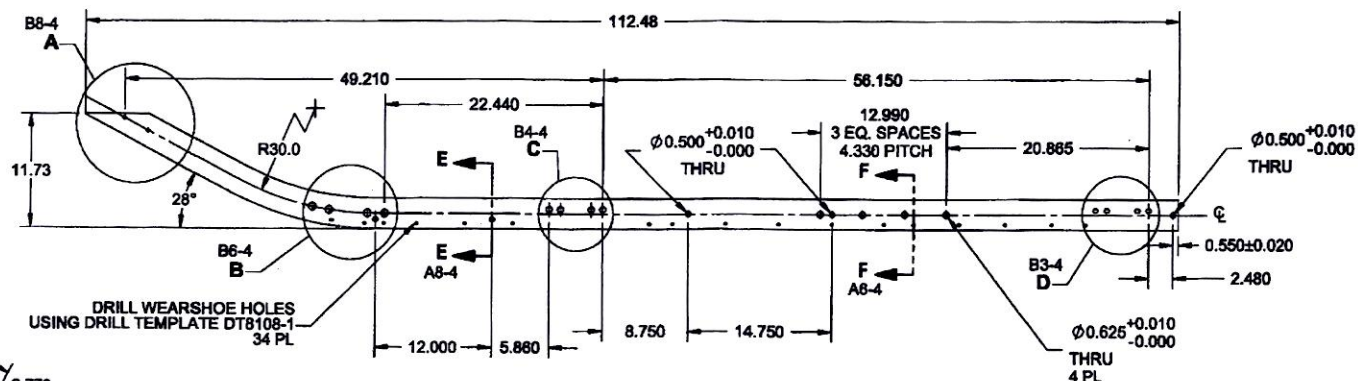


D2750-044 350 SKIDTUBE ASSEMBLY, RH

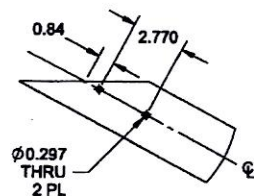
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WAP

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CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

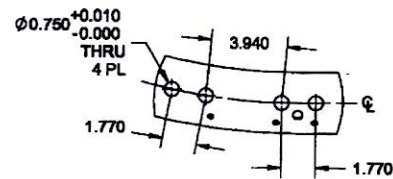
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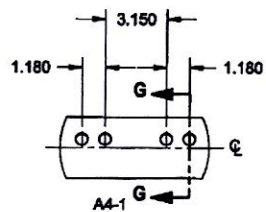
D2750-1 LH SKIDTUBE



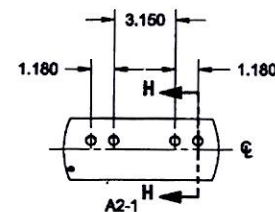
DETAIL A
SCALE 2X



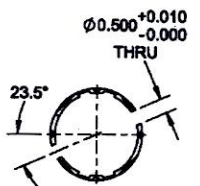
DETAIL B
SCALE 2X



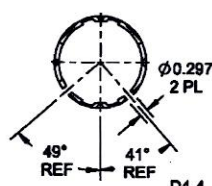
DETAIL C
SCALE 2X



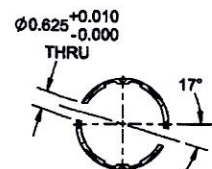
DETAIL D
SCALE 2X



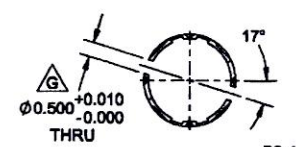
SECTION E-E
SCALE 3X, 2 PL



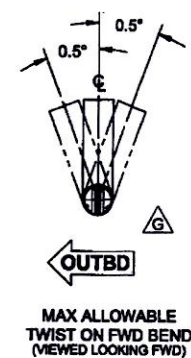
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL



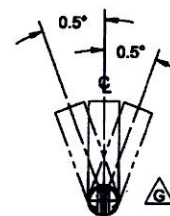
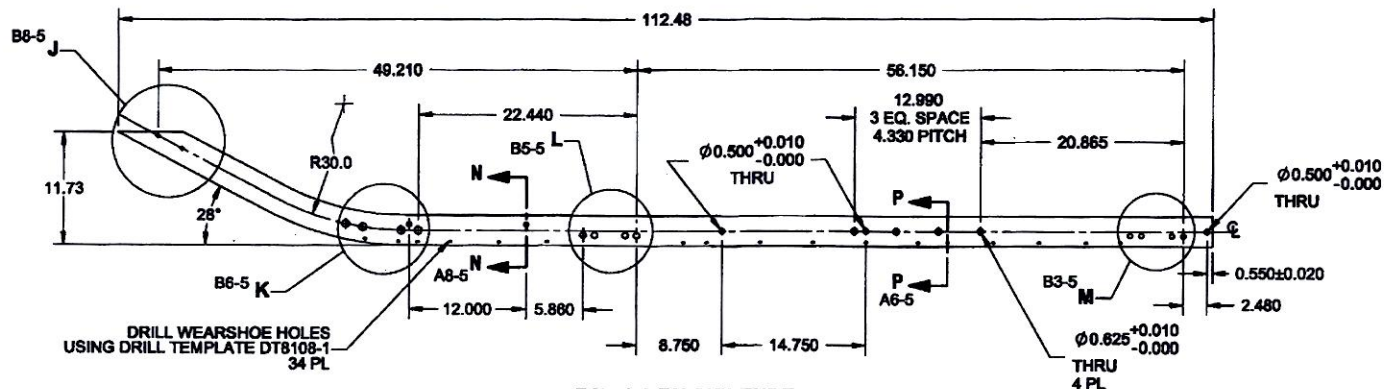
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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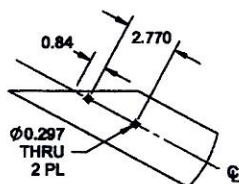
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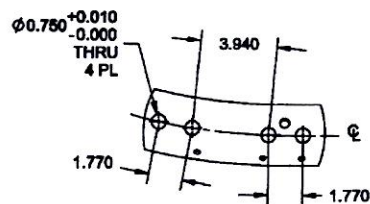
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

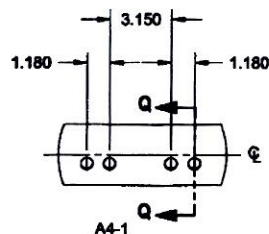
D2750-2 RH SKIDTUBE



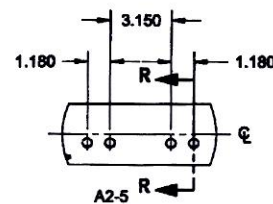
D8-5
DETAIL J
SCALE 2X



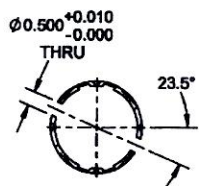
C7-5
DETAIL K
SCALE 2X



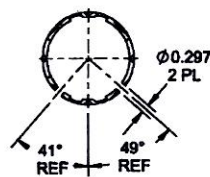
D6-5
DETAIL L
SCALE 2X



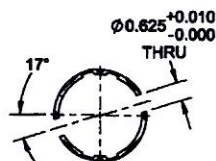
C3-5
DETAIL M
SCALE 2X



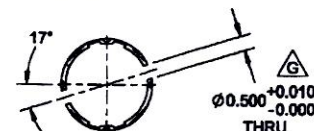
C6-5
SECTION N-N
SCALE 3X, 2 PL



C4-5
SECTION P-P
SCALE 3X, 17 PL



B5-5
SECTION Q-Q
SCALE 3X, 4 PL

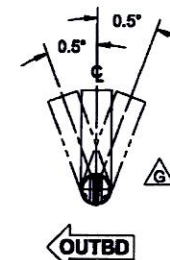
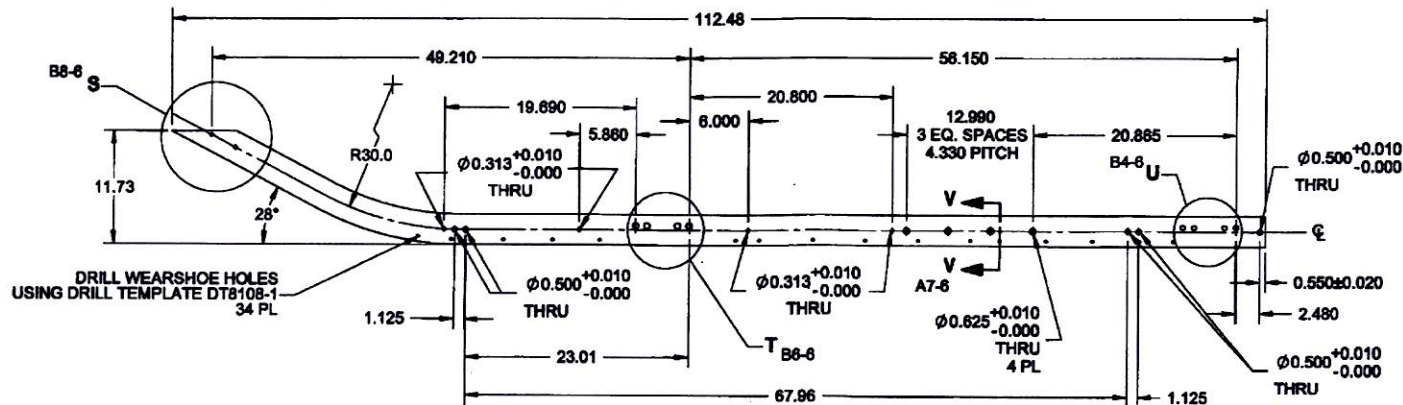


B3-5
SECTION R-R
SCALE 3X, 4 PL

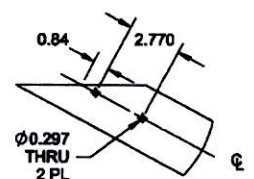
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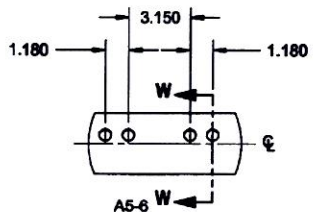
8 7 6 5 4 3 2 1



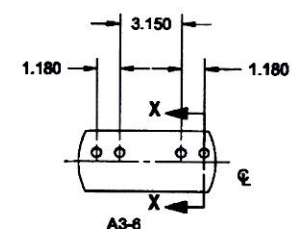
D2750-3 LH SKIDTUBE



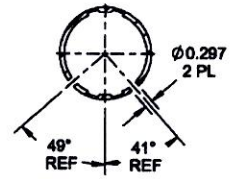
DETAIL S
SCALE 2X



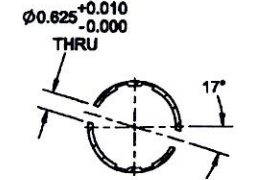
DETAIL T
SCALE 2X



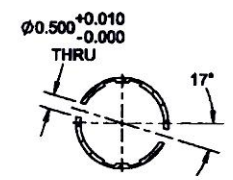
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

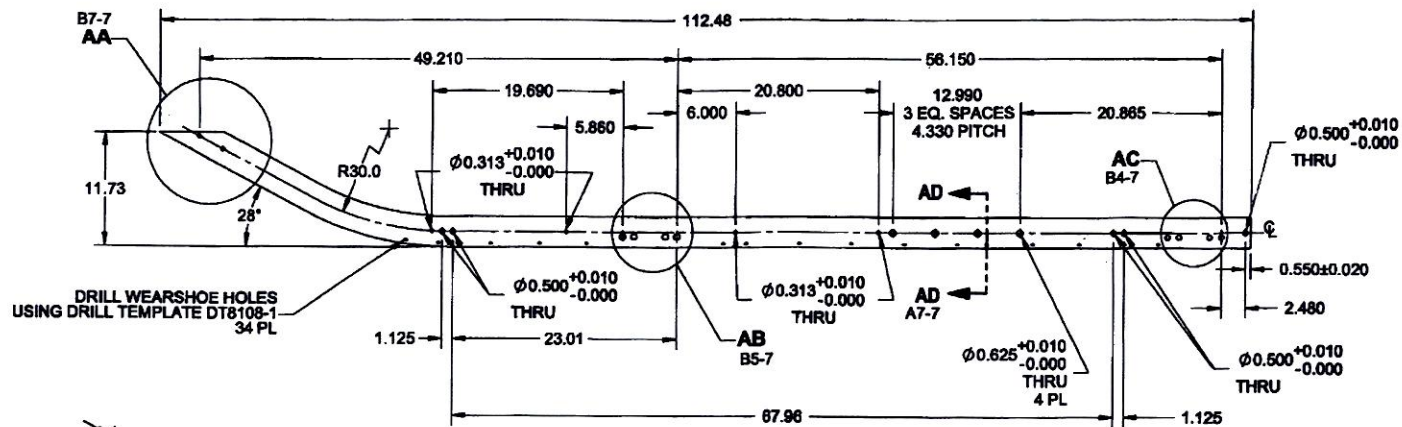


SECTION X-X
SCALE 3X, 4 PL

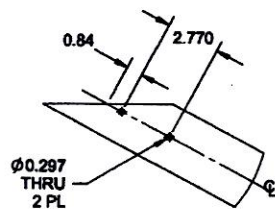
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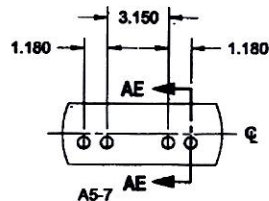
8 7 6 5 4 3 2 1



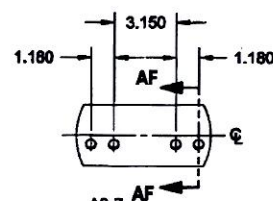
D2750-4 RH SKIDTUBE



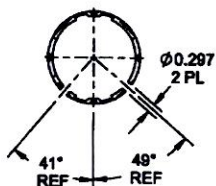
DETAIL AA
SCALE 2X



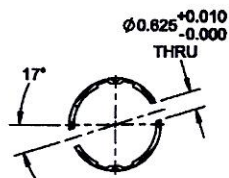
DETAIL AB
SCALE 2X



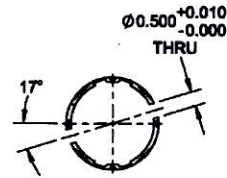
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

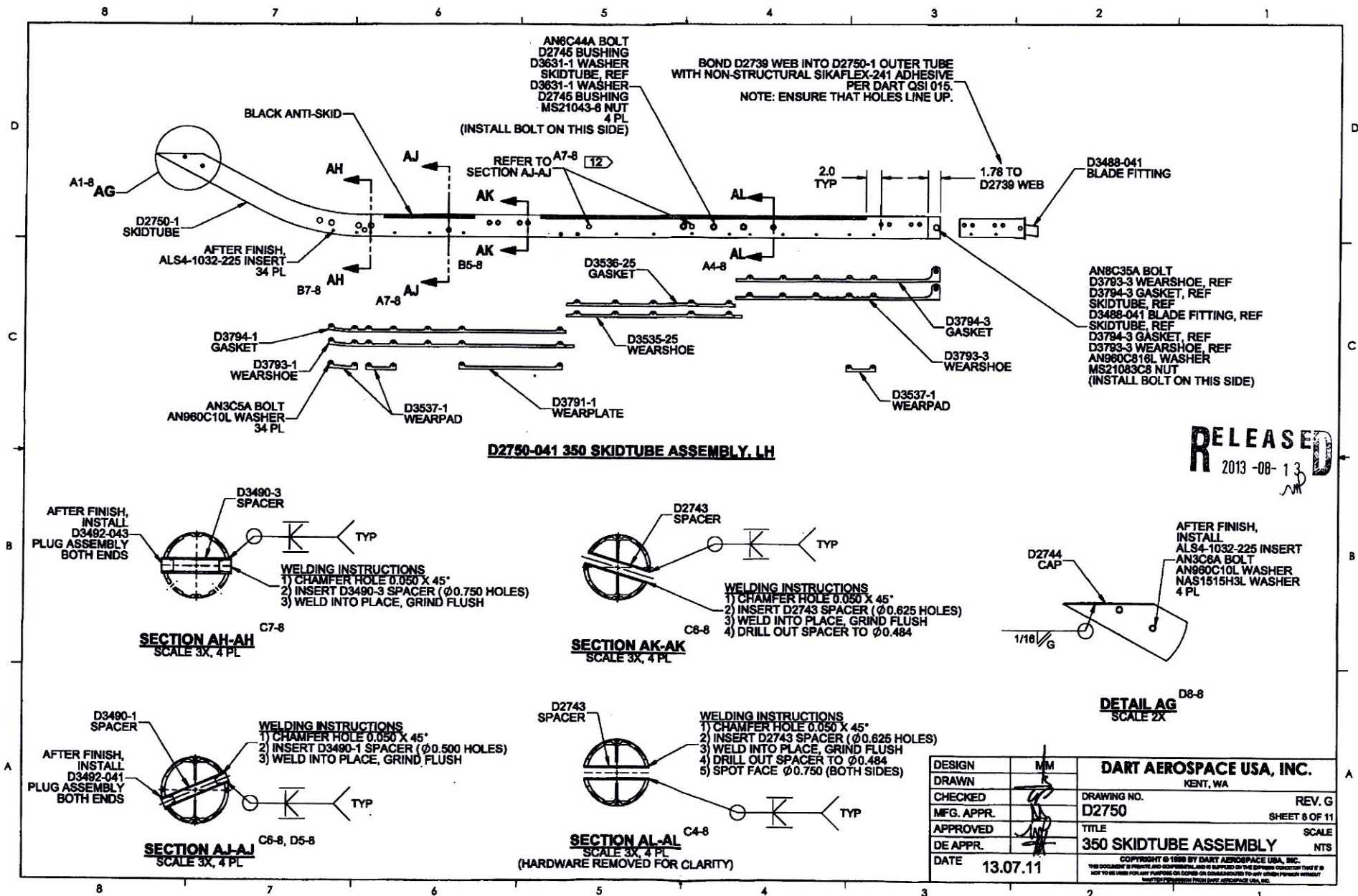


SECTION AF-AF
SCALE 3X, 4 PL

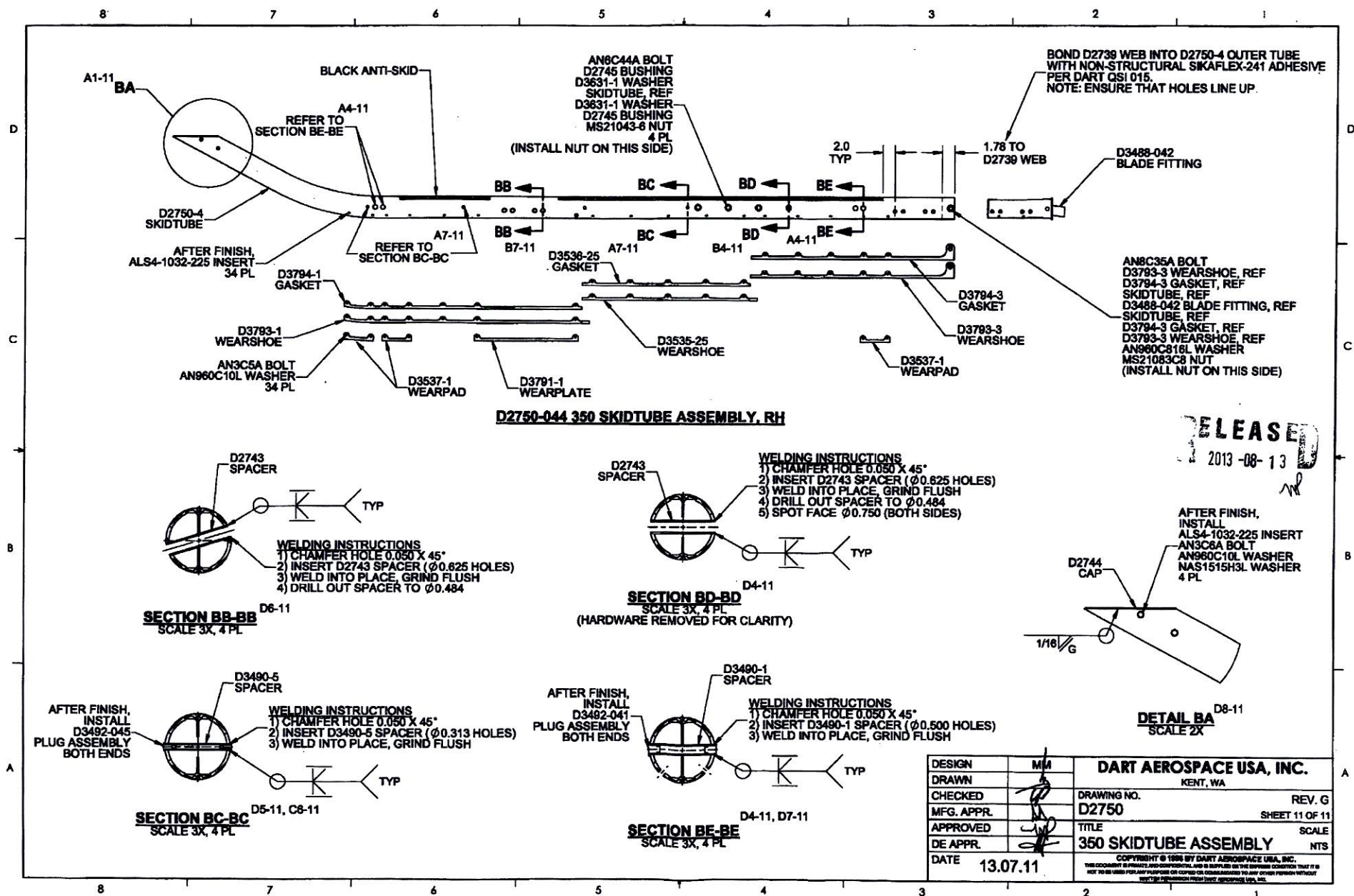
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D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

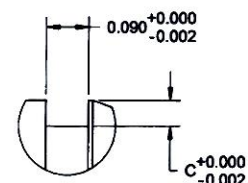
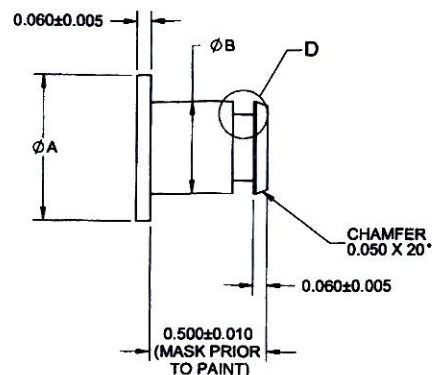
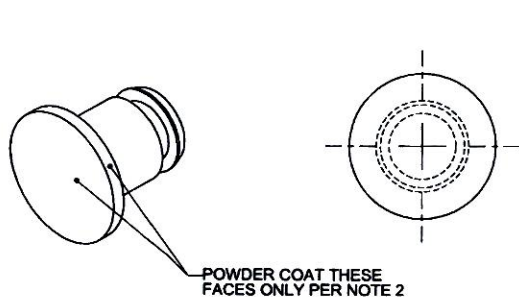
D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
	1					1		NAS1611-012	O-RING
					1			NAS1611-013	O-RING
						1	1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2013-11-13

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D3492	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	PLUG	NTS
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DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

△

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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2013-11-13

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APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	4:1
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